

Work Order ID 130314

Wednesday, March 04, 2015 4:16:28 PM

130314

Ship Friday 13th

Page 1

Item ID: D044-662-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 3/4/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: mf Date: 15-3-5 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3075	Rev B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy bluefile & type labels per PPPD044-662-011 CHG003							
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89
MAR 09 2015

DAS
66
9-89

4
MAR 12 2015
MAR 09 2015

4X
DAS 27 9-89
DAS 46 9-89
MAR 12 2015
MAR 09 2015

4
MAR 12 2015

ML 15-03-10
C

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Page 2

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 3/4/2015 Start Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PRP D044-662-011								
	Location: <u>KG 914 014</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

4
MAR 12 2015

DAS
06

MLJ 15-03-13

MF

15-3-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Wednesday, March 04, 2015 4:16:27 PM

Page 1

130314

D044-662-011

Required Date: 3/13/2015

Required Qty: 4.00

Comments: IPP Rev:C04.02.19Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
IPP Rev:D As per ECN 932 & 862 06-07-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3075-1 *D3075-1* Bearpaw(Foot Print Only)		Manufactured	No			110	Each	0.0000	2	8			DAS 46 9-89
D2182B *D2182B* Seal(\$Per Foot)		Manufactured	No			110	f	327.4680	0.93	4		MAR 09 2015	DAS 46 9-89
					<u>Location</u>			<u>Loc Qty</u>					
					ST411			327.468					
					115189			21.5					
					128976			305.968					
4 X 4.5" D2529 *D2529* Washer		Manufactured	No			110	Each	535.0000	8	32		MAR 09 2015	DAS 46 9-89
					<u>Location</u>			<u>Loc Qty</u>					
					ST007			535					
					127909			35					
					128950			500					
D3556-1 *D3556-1* Clamp For R44 Bearpaw		Manufactured	No			110	Each	68.0000	4	16		MAR 09 2015	DAS 46 9-89
					<u>Location</u>			<u>Loc Qty</u>					
					ST542			68					
					114426			40					
					121712			28					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Wednesday, March 04, 2015 4:16:27 PM

Page 2

Work Order ID: 130314

130314

Parent Item: D044-662-011

D044-662-011

Parent Item Name: Bearpaw

Start Date: 3/4/2015

Required Date: 3/13/2015

Start Qty: 4.00

Required Qty: 4.00

D3601-1

Manufactured No

110

Each

106.0000

32

D3601-1

Radius Block

DAS
06
9-89

**

DAS
27
MAR 09 2015
DAS
46
9-89

Location

Loc Qty

Loc Code

ST051A

106

124090

106

Purchased

No

110

Each

250.0000

16

AN4-14A

AN4-14A

Bolt

**

DAS
27
MAR 09 2015
DAS
46
9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

ST325A

230

131677

100

M131153

130

ST344

15

M130716

15

Purchased

No

110

Each

438.0000

16

AN4-15A

AN4-15A

Bolt

**

DAS
27
MAR 09 2015
DAS
46
9-89

Location

Loc Qty

Loc Code

GA

38

120449

38

ST325A

308

m130358

8

m131320

300

ST343

92

m131305

92

DAS
06
9-89

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Page 3

Work Order ID: 130314

130314

Parent Item: D044-662-011

D044-662-011

Parent Item Name: Bearpaw

Start Date: 3/4/2015

Required Date: 3/13/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

110

Each

4,854.000

8

32

NAS1149D0463.I

WASHER

DAS
46

DAS
27

9-89

9-89

MAR 09 2015

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

384

M129390

384

ST260a

3000

M131624

3000

ST269

1073

M129390

530

M130799

543

MS2104214

Purchased

No

110

Each

3,469.000

8

32

MS2104214

Locknut

DAS
46

DAS
27

9-89

9-89

MAR 09 2015

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

1140

m130799

56

m131340

1084

ST305

1583

426

426

m128300

8

m128798

4

m130922

97

m131618

1048

DAS
86
9-89

Wednesday, March 04, 2015 4:16:27 PM

Shop Packet Print

Page 3

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Ref

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
4	4		D2482B045	Rubber Cushion
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		AN9601D416	Washer
8	8	4	MS21042-4	Nut (or MS21042-4)

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Revision: D

Date: 07.02.14